

Date: Thursday, 09/10/2008 10:23:18 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	EC 135 SKIDTUBE ASSEMBLY
Job Number :	42525		
Estimate Number :	12472		
P.O. Number :		Part Number :	D135751011
This Issue :	09/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3507 UNDER REVIEW <i>Rev C</i>
First Issue :	//	Project Number :	N/A
Previous Run :	41333	Drawing Revision :	C
	Type :	Material :	
	SKIDTUBES	Due Date :	05/11/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<i>JLD 08.10.09</i>		
Comment :	Est Rev:A 06-06-21 New Issue JLM Est Rev:B 06-12-18 As per Rev B JLM Est Rev:C 07-12-11 ECN 1036 as per revB DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

2.0	D2962150	3.540 Outer Tube, Extrut
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion *28672**RT 08-10-15*

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

RT 08-10-15

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

RT 08-10-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185 *RT 08-10-14*

2-Cut Aft end at VC using DT8185

3-Deburr ends

4-Drill Aft & Fwd Cap holes using DT8678 + *DT8901*

5-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with *1/8" AFT CAP* in Ground wire hole, then Pilot Drill all X-Bolt holes using *#30* 3/16" drill. ****DO NOT OPEN AFT CAP HOLES**** *open x bolt holes to .3125*

7-Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES. *ND/ 8-10-23*

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3507.

9-Open Aft & Fwd Cap holes using .208" drill. *AWM 8-10-27*

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Deburr holes.

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *S 081027*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *D 8-10-28*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *8-10-28*

W/O:		WORK ORDER CHANGES					
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9.0	D35043	Crossbolt Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSBOLT SPACER

Batch: B31232

BE 08/10/30

10.0	D35041	Crossbolt Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

Batch: B31234

BE 08/10/30

11.0	D35051	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Batch: B341604

DP 8-10-28

12.0	D35061	Doubler
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

DOUBLER

Batch: 41605

SL 8-10-31

13.0	D35063	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

Batch: 28963

SL 8-10-31

14.0	D35045	Crossbolt Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

Batch: B336181

BE 08/10/30

15.0	MS20601AD4W3	Rivet
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch: 107823

SL 8-10-31

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #: Machine Or Operation: Description :

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: M109449
Exp Date: 8-11-30

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: m109213 8-10-30

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

Handwritten signature
8-10-28

Handwritten signature
08-10-30

Tools: E

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

Handwritten signature
08/10/31 (+0)

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet D3506-1/-3 as per Dwg D3507.

Handwritten signature
SL 8-10-31

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten signature
08/10/31 (+0)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #: Machine Or Operation: Description :

20.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(P)

Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005

FZ 08/11/05

21.0 POWDER COATING POWDER COATING



M109152



(TX)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20
320 OF
9:50

M-F 08/11/05

22.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-06

(X)

23.0 ALS71032130 Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: M105819

HL *

24.0 ALS41032225 Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: M100621

HL

25.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3507.

HL 08-11-06 (X)

26.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

S 08/11/06 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42525

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	AN526C1032R10	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch M 108062

Handwritten signature

28.0	D29653	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B 29993

Handwritten signature

29.0	D2965	Cap, 105 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B 41523

Handwritten signature

30.0	D35081	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B 31195

Handwritten signature

31.0	D35083	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B 38527

Handwritten signature

32.0	D35085	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B 31197

Handwritten signature

33.0	D35087	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B 36179

Handwritten signature

08.11.06

Handwritten mark (V)

W/O:		WORK ORDER CHANGES					
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Job Number: 42525

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	D35581	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342533

24

35.0	D35583	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342253

24

36.0	D35585	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 134132411

24

37.0	D35587	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1336388

24

38.0	D3492041	Plug Assembly
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY

Batch: 1342637

24

39.0	D3492043	Plug Assembly
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY

batch 1342183

24

40.0	D3492047	Plug Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

Batch: 1528961

24

08.11.00

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42525

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	AN960C10L	washer
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Comment: Qty.: 33.0000 Each(s)/Unit Total : 33.0000 Each(s)

Washer

Batch: (12x) M109545 (21x) M109752 JK

42.0	AN3C4A	BOLT
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Comment: Qty.: 31.0000 Each(s)/Unit Total : 31.0000 Each(s)

BOLT

Batch: M109431 JH

43.0	AN3C5A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109752 JH

44.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

- ✓ 1-Inspect for Foreign objects
- ✓ 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"
A/R 241 Sika Flex Batch: M109449
Exp Date: 08/11
- ✓ 3-Install Wearplates as per Dwg D3507 ,
Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Screws where indicated on Dwg (Note #6)
A/R 241 Sika Flex Batch: M109449
Exp Date: 08/11
- ✓ 4-Install Plug assemblys as per Dwg D3507.

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Dwg 3507
M109219. →

HP on 08-11-06 (X)
Fol 08/11/06 (1)

W/O:		WORK ORDER CHANGES					
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Part Number: D135751011

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Seq. #:	Machine Or Operation:	Description :
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45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/13 (1)
plugs installed

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

47.0

D35121

Wearplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WEARPLATE

Batch: 40360

SS 08/11/13 (X1)

48.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M105793

SS 08/11/13 (X1)

49.0

AN3C4A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

BATCH: M109001

Batch not in comp

SS 08/11/13 (X1)

50.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/11/13 (1)

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-751-011

Location: 82

PPP Rev: B

8/11/13

(15)

54

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/14 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-13

B42525

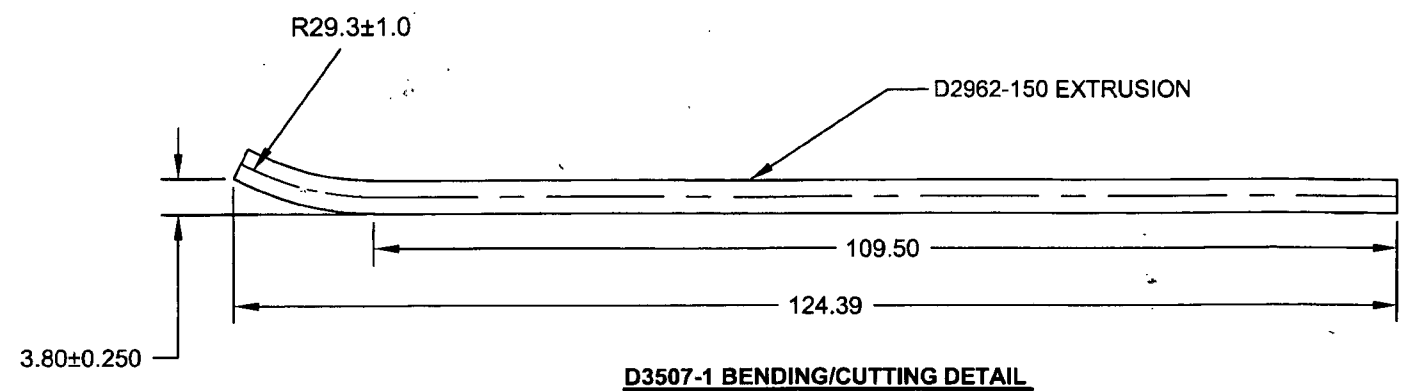
W/O:		WORK ORDER CHANGES					
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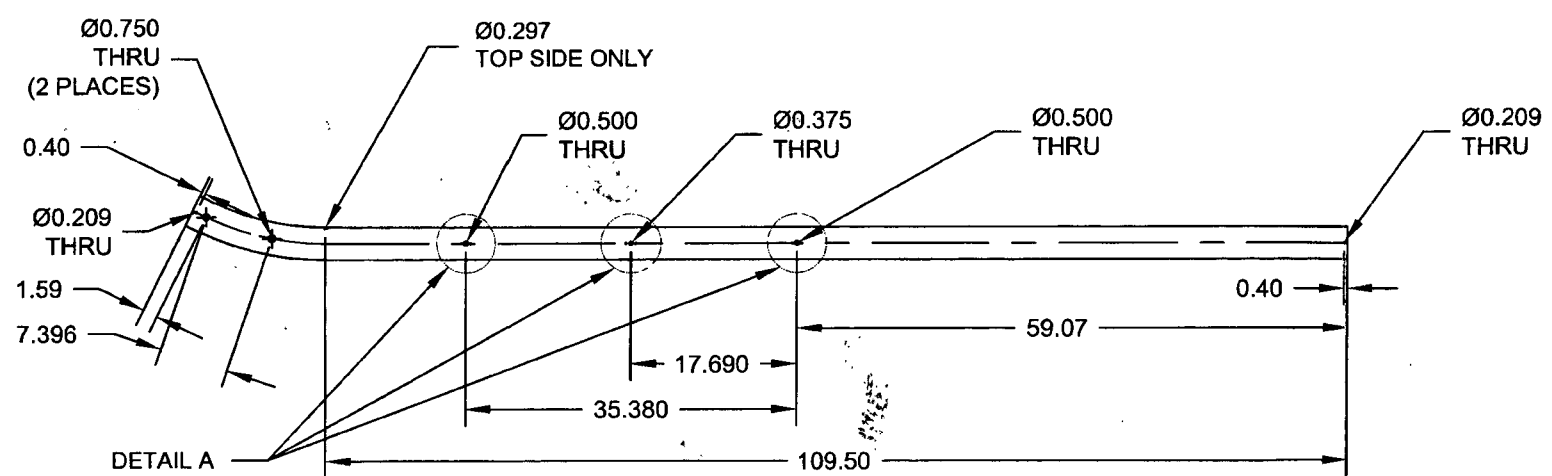
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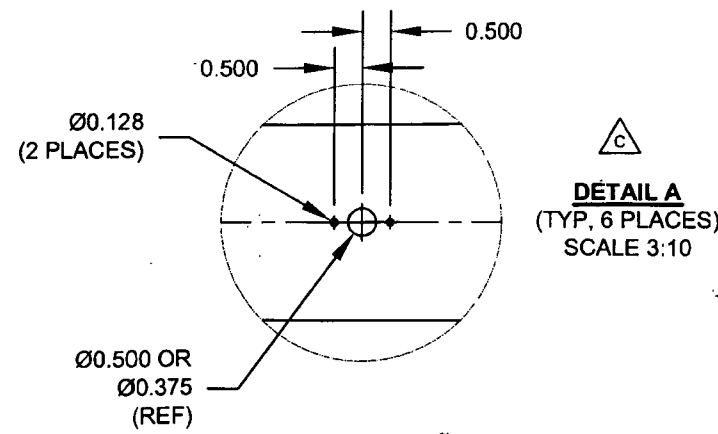
NOTE: Date & initial all entries



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

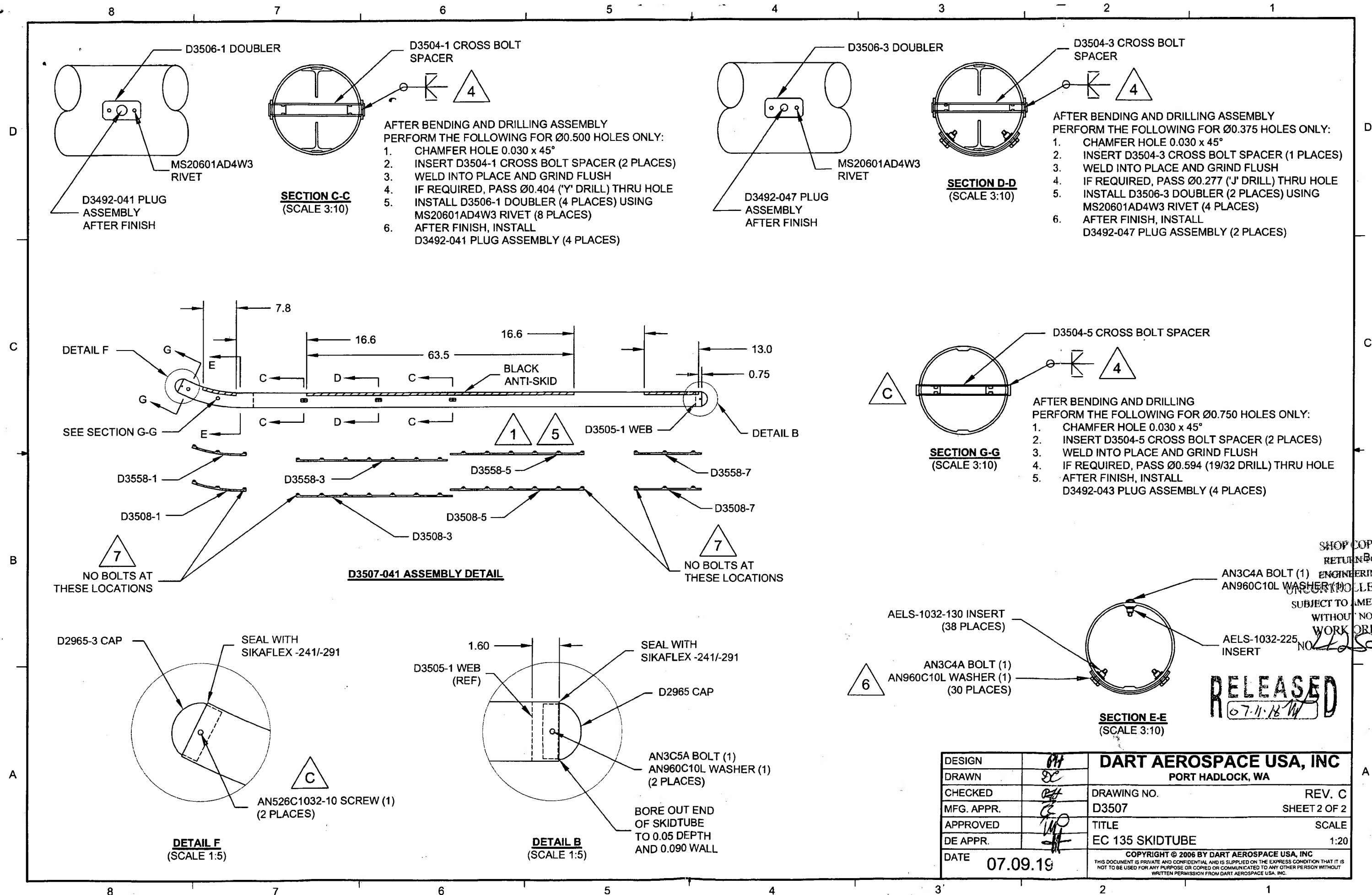
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

RELEASED
07-11-16

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	DC		
CHECKED	PH		
MFG. APPR.	EP		
APPROVED	PH		
DE APPR.	PH		
DATE	07.09.19		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO. D3507	REV. C
TITLE EC 135 SKIDTUBE	SHEET 1 OF 2
SCALE	NTS
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NO. 22028



NO. 179

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 841333
Part number: 135 751011
Description: SKID tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David David Date of Test Coupon 08/10/22

Welder Barclay Elliot Date of Test Coupon 08/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld